

Date: Wednesday, 07/03/2007 2:27:09 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 30889
 Estimate Number : 11535
 P.O. Number : *N/A* Part Number : D30403
 This Issue : 07/03/2007 S.O. No. : *N/A* Drawing Number : D3040 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 30889 Material : *N/A* Due Date : 30/03/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: B 01.11.08 Revised Step 2 and Added Inspection Level 21 S
 M
 Est Rev: A Now on Waterjet 07-03-07 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0187X04000 6061-T6 Bar .178" x 4.0"



Comment: Qty.: 0.3718 f(s)/Unit Total : 7.4361 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 alum plate 0.188" thick

Batch *m103857* *ml 07 04 10* (20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3041
 Dwg Rev: *B*
 Prog Rev: *B*

ml 07 04 10

Jan 07/04/17 (20)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 04 10

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/04/12

(21)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA25*

07-04-18 21

Date: Wednesday, 07/03/2007 2:27:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30889

Part Number: D30403

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

207/04/19

Job Completion



U 07-04-19

Date: Friday, 2/23/2007 8:31:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30889		
Estimate Number	: 11535		
P.O. Number	:	Part Number	: D30403
This Issue	: 2/23/2007 S.O. No. :	Drawing Number	: D3040 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>07.02.23</u>		
Comment	: Est.B 01.11.08 Revised Step 2 and Added Inspection Level 21S M		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
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Comment: Qty.: 0.3718 f(s)/Unit Total : 7.4361 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 alum plate 0.188" thick

Batch: W4092

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 4.25" x 3.48" tol. +/-0.010"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA155

Tumble and deburr rough edges after tumbling

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30889

Part Number: D30403

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/23/07/19 (21)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

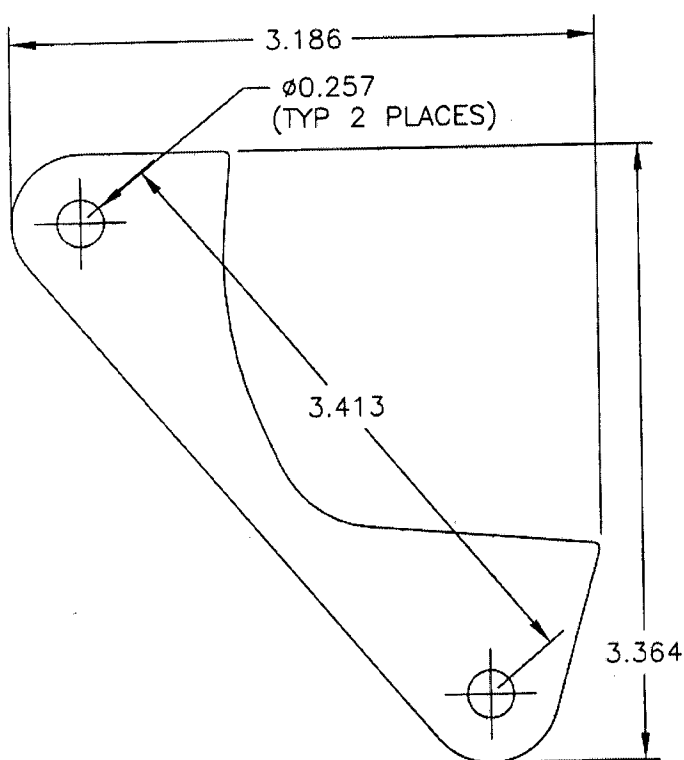
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

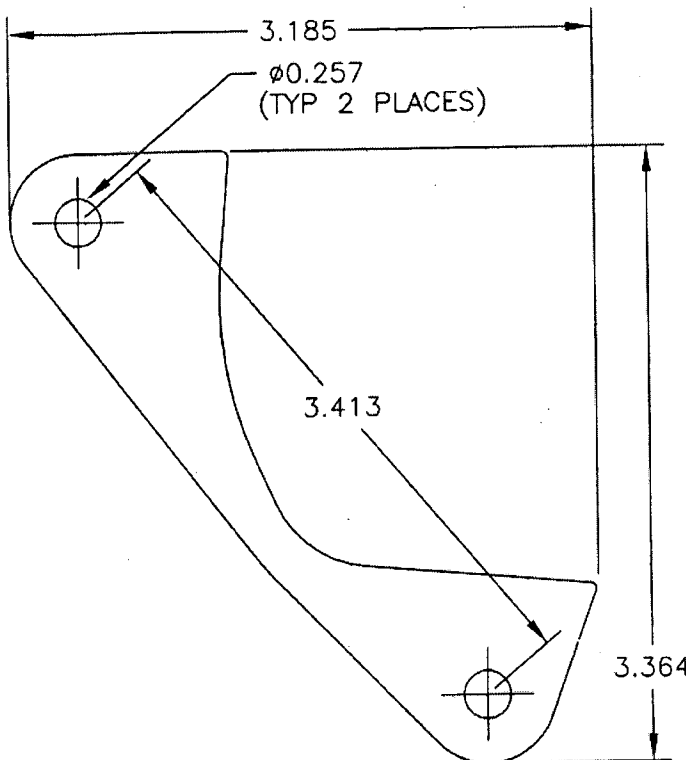


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	REV. B
CHECKED	#	APPROVED	#	PORT HADLOCK, WA	
DATE	01.09.04	DRAWING NO.	D3040	SHEET 1 OF 1	
		TITLE	MOUNTING LUG	SCALE	1:1
A	01.06.27	NEW ISSUE			
B	01.09.04	CHANGED PROFILE 5 DEGREES			

RELEASED
01.09.07



D3040-1



D3040-3

NOTES

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
(REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
30889

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DART AEROSPACE LTD		Work Order: 30889
Description: Mounting Lug		Part Number: D3040-3
Inspection Dwg: D3040 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A ϕ 0.257	+0.006-0.001	0.258	✓		vern	
B 3.413	+1-0.010	3.413	✓		vern	
C 0.188	+1-0.010	0.187	✓		vern	
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM. MM</i>
Date: 07 04 10

Audited by: <i>MM</i>
Date: 07/04/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

Handwritten signature